

5/46

Ady (39)

DART AEROSPACE LTD	Work Order:	24673
Description: Handle Escutcheon RF 04.11.29	Part Number:	D3110-1
Dwg: D3110 Rev. A1 B	Qty:	6 5

Step	Location	Procedure	By	Date	qty
1	EXPEDITING	Issue W/O	RF	05.10.26	5
2	METAL	Cut blanks: 6.400" x 1.25" x .25" thick Note: 1 blank makes 2 parts Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-225/8) Batch: M10956			3
3	CNC CELL	Machine as per folio FA215	J.L.	05.11.08	6
4	QC	Inspect Level 2	J.L.	05.11.08	6
5	QC	Inspect Level 8	EN	05.11.08	6
6	CNC-CELL	Tumble or Deburr Polish to a high lustre!	EN	05.11.08	6
7	CNC-CELL	Engrave part # on back of part with vibrating pencil. fine point permanent ink marker	EN	05.11.08	6
8	QC	Inspect Level 5	EN	05.11.08	6
9	STORES	Identify and stock	CD	05.11.08	6
10	EXPEDITING	Inspect Level 21 Close W/O Cost / part: 17.89 545 05/11/10 (6)			

20.63

Rev	Date	Change	Revised By	Approved
A	01.04.10	New Issue	NG	
B	01.04.30	Added Rev.A1	NG	CP 2002/5/01

RELEASED

02/04/80

MIS only

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

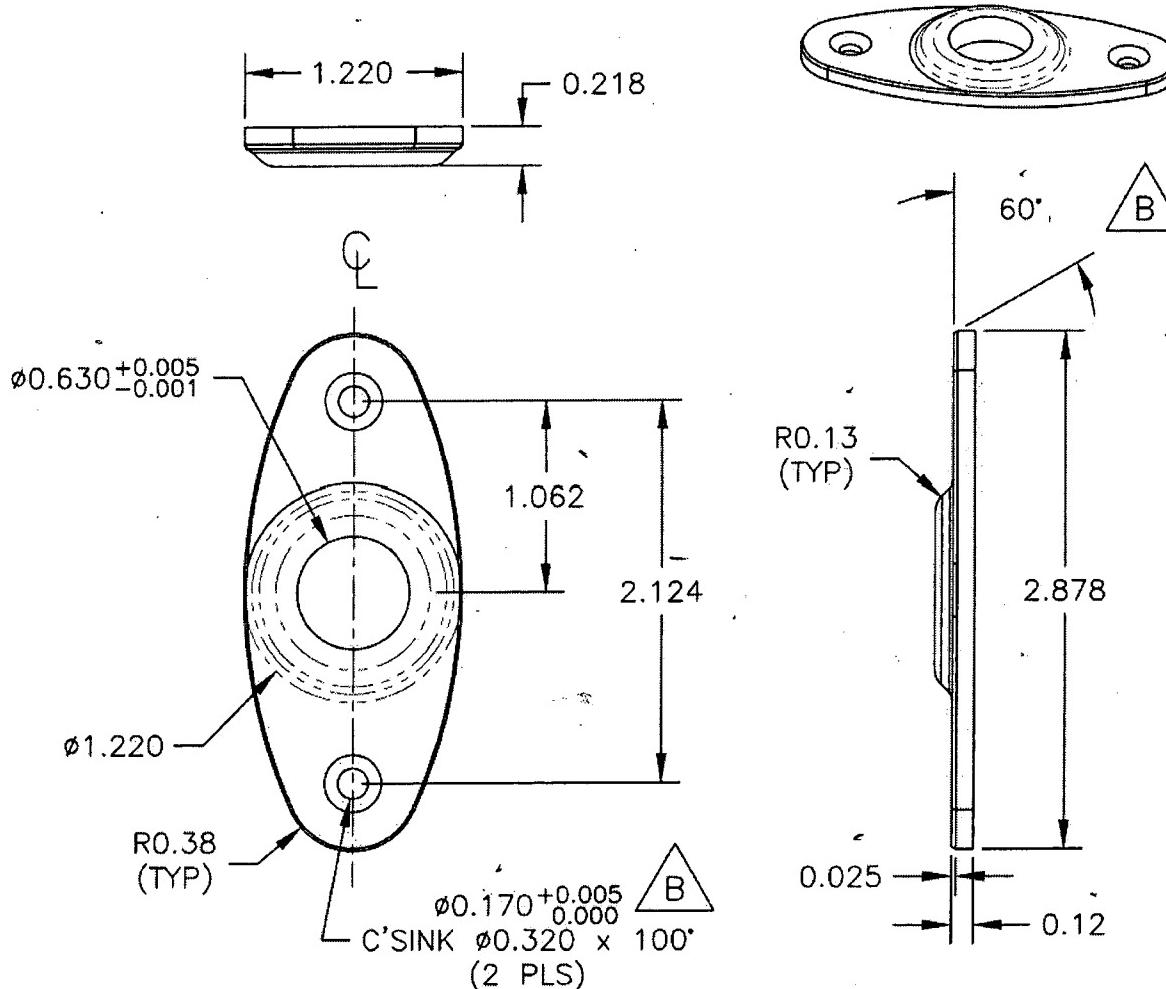
NOTE: Date & initial all entries



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DRAFT

DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3110	SHEET 1 OF 3
DATE		TITLE	SCALE
04.10.18		HANDLE	1:1
A	02.04.11	NEW ISSUE	
B	04.10.18	ADD PART MARKING, TOLERANCES	

RELEASED
04.11.23



D3110-1 ESCUTCHEON

NOTES:

- 1) MATERIAL: 6061-T6 BAR (QQ-A-200/8 OR QQ-A-225/8) 0.250 THICK (M6061T6B)
- 2) FINISH: POLISHED
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) REPLACES ADAMS RITE P/N AR75
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

SHOP COMP

RETURN TO

ENGINEERING

UNCONTROLLED CO

SUBJECT TO ADOPTION

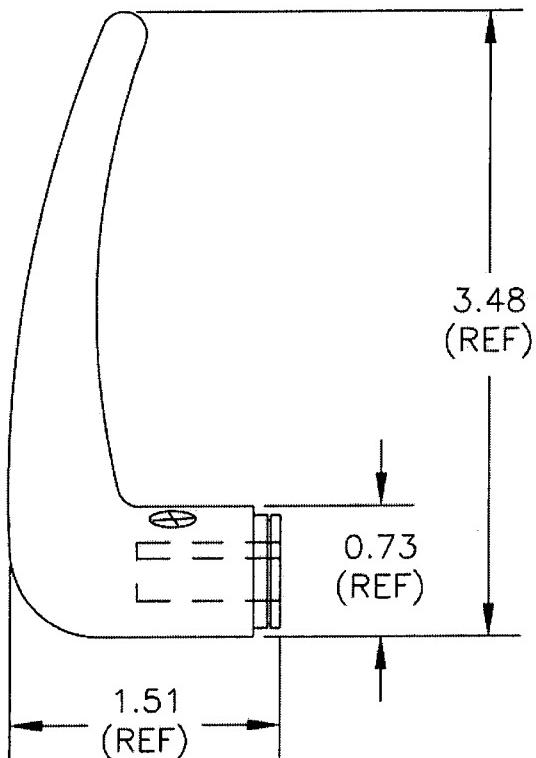
WITHOUT NOTICE

WORK ORDER

NO. 24673

DART

DESIGN <i>[initials]</i>	DRAWN BY <i>[initials]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3110	REV. B SHEET 2 OF 3
DATE 04.10.18		TITLE HANDLE	SCALE 1:1

RELEASED
04.11.23 *[initials]***D3110-3 HANDLE****NOTES:**

- 1) POSSIBLE SUPPLIERS: ADAMS RITE P/N AR34
BELL P/N 70-027-1
PREMIER P/N 034-23002-01
- 2) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

SHOP CO'

RET/JOHN T.

ENG INEFP

MANUFACTURE

INK MARKER

SUBJECT 1

WITHOUT CHG

WORK ORDERS

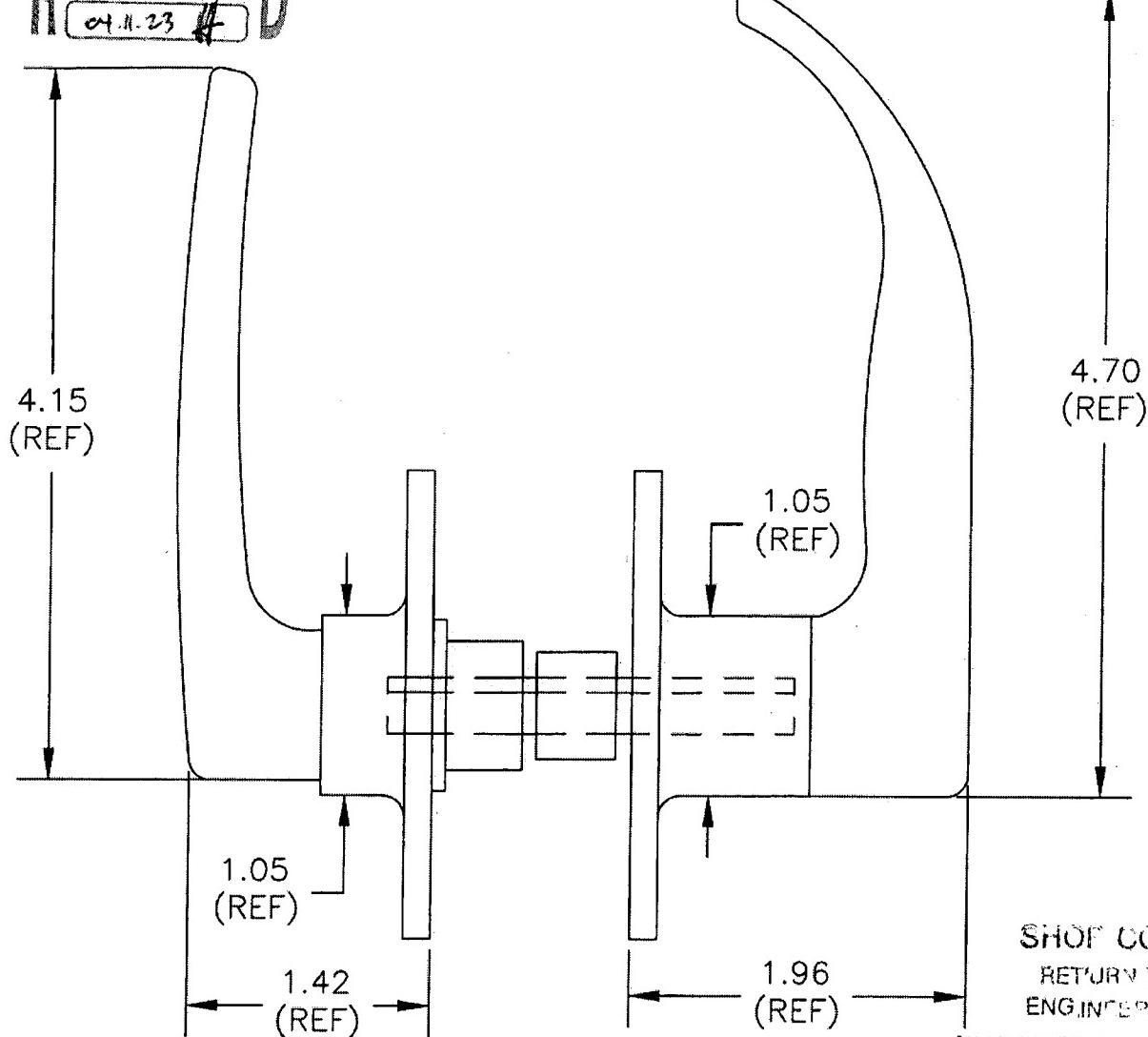
24673

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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3110 REV. B SHEET 3 OF 3
DATE 04.10.18		TITLE HANDLE SCALE 1:1

RELEASED
04.11.23**D3110-5 HANDLE**

SHOP COPY
RETURN TO
ENG. ING.
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SUBJECT TO CHANGE
WITHOUT NOTICE

WORK IN PROGRESS

NO 24673

NOTES:

- 1) POSSIBLE SUPPLIER: ADAMS RITE P/N 4298
- 2) IDENTIFY WITH PART P/N USING FINE POINT PERMANENT INK MARKER

Job Costing Report

Dart Aerospace Ltd.
HawkesburyOct 25, 2005
04:04 pm

Work Order No : 0024673
 Project Name : D3110-1
 Project For : WK546
 Work Order Type : Main
 Main WO Number :
 House Part Number : D3110-1
 Description : Handle
 Manufactured : Yes
 Amount Req'd : 5
 Amount Done : 0
 Start Date : 10-25-05
 Est Finish Date : 11-15-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd :
\$0 Posted to Finished Goods

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00
 Order Entry No :
 OE Value : 0.00
 Est Mark Up : 0.000%
 Actual Mark Up : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden :	0.00	0.00	0.00		
<hr/>					
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	0.00

DART AEROSPACE LTD

Work Order: 24673

Description: escutcheon

Part Number: A3110-1

Inspection Dwg: A3110

Rev: 6

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article

1

Prototype

Measured by:

71

Audited by:

2

Prototype Approval:

Date:

05.11.08

Date:

05/11/08

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
12:44 pm

Work Order No	:	0024673	Department Code:		
Project Name	:	D3110-1	Burden Flags	:	NNNNNNN
Project For	:	WK546	WO Status	:	Open
Work Order Type	:	Main	Invoice State	:	Not Invoiced
Main WO Number	:		Invoice Date	:	
House Part Number	:	D3110-1	Invoice Number	:	
Description	:	Handle	Invoice Amount	:	0.00
Manufactured	:	Yes			
Amount Req'd	:	5			
Amount Done	:	0	Order Entry No	:	
Start Date	:	10-25-05	OE Value	:	0.00
Est Finish Date	:	11-15-05			
Act Finish Date	:		Est Margin	:	0.000%
Drawings Reqd	:	No	Actual Margin	:	0.000%
Ok for Approval	:				
Approval Rec'd	:		\$0 Posted to Finished Goods		

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	:	0.00	0.00	0.00	0.00
Engineering Hours	:	0.00	0.00	0.00	0.00
Engineering Cost	:	0.00	0.00	0.00	0.00
Production Hours	:	0.00	0.00	0.00	0.00
Production Cost	:	0.00	0.00	0.00	0.00
Packaging Hours	:	0.00	0.00	0.00	0.00
Packaging Cost	:	0.00	0.00	0.00	0.00
OverHead Hours	:	0.00	0.00	0.00	0.00
OverHead Cost	:	0.00	0.00	0.00	0.00
CNC Hours	:	0.00	0.00	0.00	0.00
CNC	:	0.00	0.00	0.00	0.00
Misc. Hours	:	0.00	0.00	0.00	0.00
Misc.	:	0.00	0.00	0.00	0.00
<hr/>					
Burden	:	0.00	0.00	0.00	
<hr/>					
Total Cost	:	0.00	0.00	0.00	
Margin	:	0.000	0.000		
Selling Cost	:	0.00	0.00		

	Estimated	Actual	
Labour Hrs/Amount Done	:	0.00	0.00
Profits/ (Loss)	:	0.00	0.00